

Work Order ID 59607

Tuesday, June 08, 2010 3:08:46 PM



Page 1

| | | | | | | |
|----------------|----------------------------------|------------|------|-------|-------|--|
| Item ID: | D4018-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | | |
| Item Name: | Short Basket Lid Assembly (350) | | | | Stop | |
| Start Date: | 6/9/2010 | Start Qty: | 1.00 | | | |
| Required Date: | 6/14/2010 | Req'd Qty: | 1.00 | | | |
| Reference: | | | | | | |
| | | | | | | |

| | | | | | | | | | | | |
|------------|---------------|------------|-------|--------------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | <i>CMF</i> | Date: | <i>6-6-8</i> | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4018 | B |

100 Weld per dwg A/R S.S. rod Batch: *M413328* 0.00
Large Fab



Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
make sure to place mesh correctly on lid, check with label plate before tacking mesh

24 10/06/10 *(12)*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

Memo

0.00

6/10.06.14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D4018-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Lid Assembly (350)

Stop



Start Date: 6/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

ES 10/06/15 ①

160



Packaging

Packaging

Identify as per dwg & Stock Location: *G-A*

0.00

w/o B59605
Memo

0.00

ES 10/06/15 ②

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/15 *MF* 10-6-15

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NOTE: Date & initial all entries

Picklist Print

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3

Work Order ID: 59607



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per dwg revA 10.03.15 verified by:EC
DD 10.04.16 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Qty per Kit | Total | Qty | Date | Status |
|--|-------------|--------------|-----|---------|------|-------|---------|---------|-------------|-------|-----|------|--------|
| ✓ D4018-1 | | Manufactured | No | | | 100 | Each | 0.0000 | 2 | 2 | | | |
| | | | | | | | | | | | | | |
| Rib | | | | | | | | | | | | | |
| ✓ D4018-3 | | Manufactured | No | | | 100 | Each | 0.0000 | 2 | 2 | | | |
| | | | | | | | | | | | | | |
| Rib | | | | | | | | | | | | | |
| ✓ D4016-3 | | Manufactured | No | | | 100 | Each | 13.0000 | 3 | 3 | | | |
| | | | | | | | | | | | | | |
| Hinge Half, Lid | | | | | | | | | | | | | |
| <div> <div>Location</div> <div>ST116</div> <div>58243</div> <div>WA</div> <div>58737</div> </div> <div> <div>Loc Qty</div> <div>7</div> <div>7</div> <div>6</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div> | | | | | | | | | | | | | |
| ✓ D4018-5 | | Manufactured | No | | | 100 | Each | 36.0000 | 6 | 6 | | | |
| | | | | | | | | | | | | | |
| Rib | | | | | | | | | | | | | |
| <div> <div>Location</div> <div>WA</div> <div>58594</div> <div>58669</div> <div>59097</div> </div> <div> <div>Loc Qty</div> <div>36</div> <div>9</div> <div>18</div> <div>9</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div> | | | | | | | | | | | | | |
| ✓ D4035-041 | | Manufactured | No | | | 100 | Each | 2.0000 | 1 | 1 | | | |
| | | | | | | | | | | | | | |
| Lid Rib Assembly, Fwd (350 Basket). | | | | | | | | | | | | | |
| <div> <div>Location</div> <div>WA</div> <div>59103</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> | | | | | | | | | | | | | |

B59608 ② SJ 10/06/10

B59609 ② SJ 10/06/10

SJ 10/06/10

③

SJ 10/06/10

⑤

SJ 10/06/10

①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 59607



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per dwg revA 10.03.15 verified by:EC
DD 10.04.16 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Qty per Kit | Total | Qty | Date | Status |
|--------------------|-------------|--------------|-----|---------|------|-------|---------|--------|-------------|-------|-----|------|--------|
| ✓ D4035-043 | | Manufactured | No | | | 100 | Each | 2.0000 | 1 | 1 | | | |



Lid Rib Assembly, Aft (350 Basket)

Location Loc Qty Loc Code

WA 2
59102 2

✓ D2581

Manufactured No

100 Each 55.0000 2



Mounting Bracket

Location Loc Qty Loc Code

ST 22
59121 22
WA 33
46086 2
51745 2
57185 1
58687 7
59265 21

D4020-7

Manufactured No

100 Each 0.0000 1



Mesh (350 Basket Short, Lid)

✓ D4021-3

Manufactured No

100 Each 6.0000 1



Data Plate

Location Loc Qty Loc Code

WA 6
56050 1
59054 5

10/06/10

10/06/10

59610. MK 10-6-15

10/06/10

Tuesday, June 08, 2010 3:08:46 PM

Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per dwg revA 10.03.15 verified by:EC
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Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Qty per Kit | Total | Qty | Date | Status |
|--------------------|-------------|--------------|-----|---------|------|-------|---------|---------|-------------|-------|-----|------|--------|
| D4086-232 | | Manufactured | No | | | 140 | Each | 10.0000 | 1 | 1 | | | |



Placard, Max Load



Handwritten signature and date: 6/10/06/15

Location

Loc Qty

Loc Code

ST112

10

56980

10

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



Handwritten signature and date: 6/10/06/15

Tuesday, June 08, 2010 3:08:46 PM

Shop Packet Print

Page 3

NO:

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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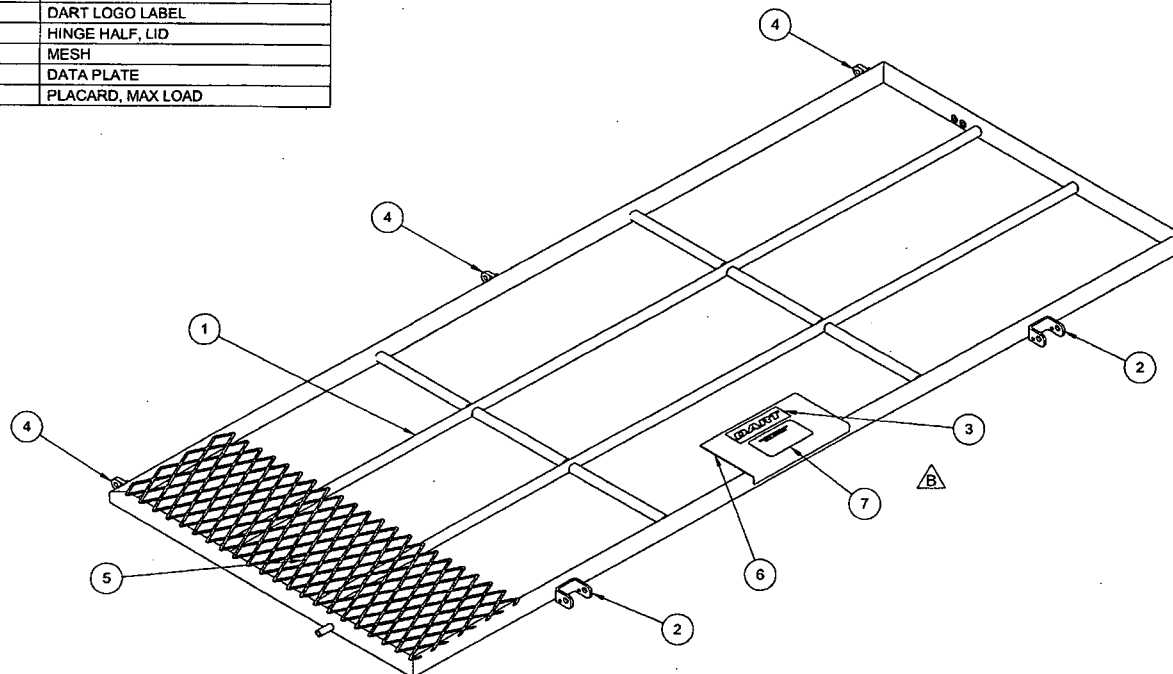
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|--------------------------------|
| | X | D4018-041 | SHORT BASKET LID ASSY (350) |
| 1 | 1 | D4018-101 | TUBULAR ASSY, BASKET LID (350) |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 1 | D2728-3 | DART LOGO LABEL |
| 4 | 3 | D4016-3 | HINGE HALF, LID |
| 5 | 1 | D4020-7 | MESH |
| 6 | 1 | D4021-3 | DATA PLATE |
| 7 | 1 | D4086-232 | PLACARD, MAX LOAD |



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

#59607

RELEASED
2010-03-31

| | | | | |
|------------|---|--|-----|----------|
| B | BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2: NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4). | | JPH | 10.03.25 |
| A | NEW ISSUE | | JPH | 10.03.04 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. B SHEET 1 OF 4 TITLE SHORT BASKET LID ASSY (350) NTS SCALE COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | |
| DRAWN | JPH | | | |
| CHECKED | | | | |
| MFG. APPR. | | | | |
| APPROVED | | | | |
| DE APPR. | | | | |
| DATE | 10.03.25 | | | |

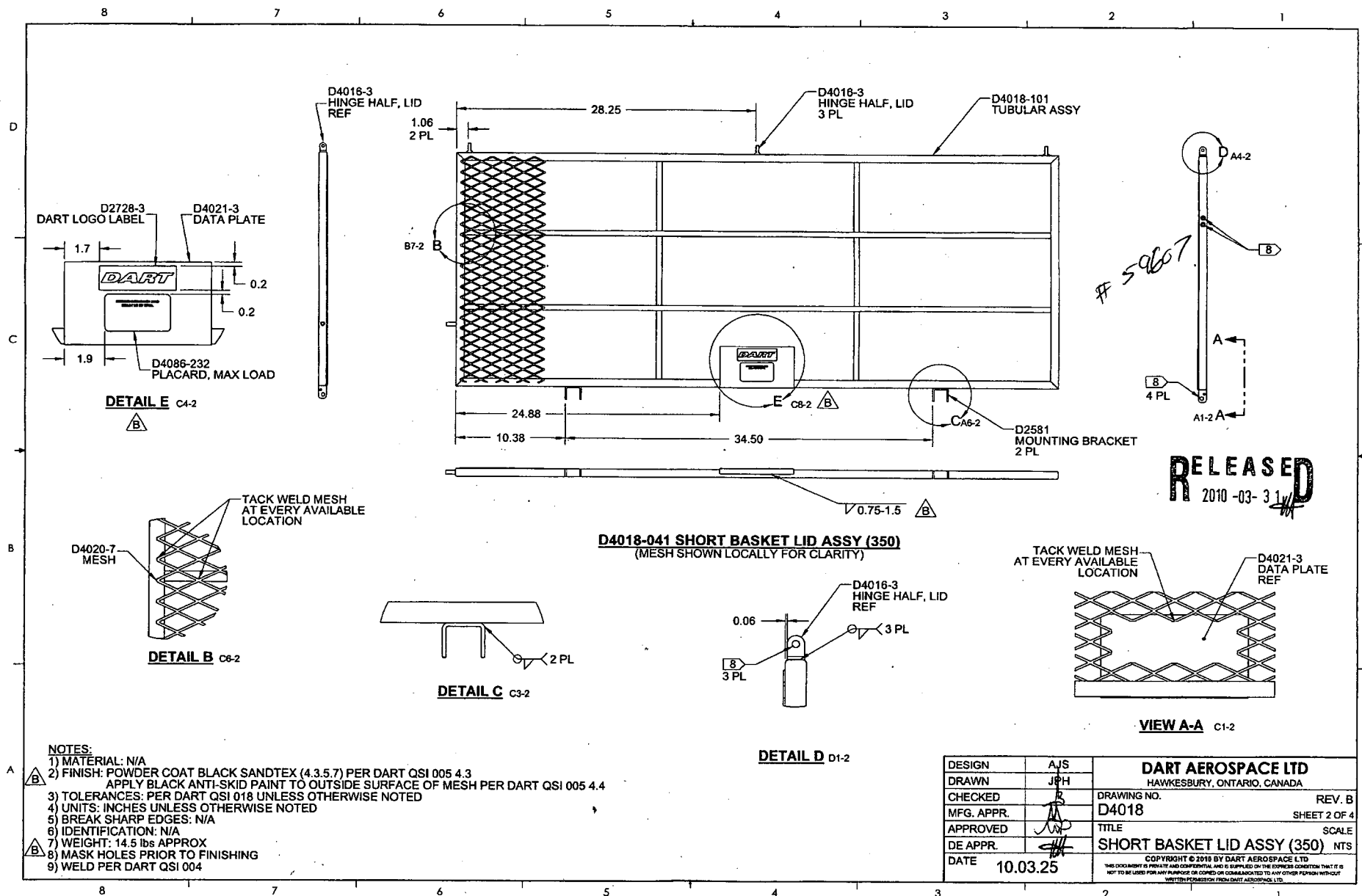
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NOTE: Date & initial all entries



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4018 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SHORT BASKET LID ASSY (350) | NTS |
| DATE | 10.03.25 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMBINED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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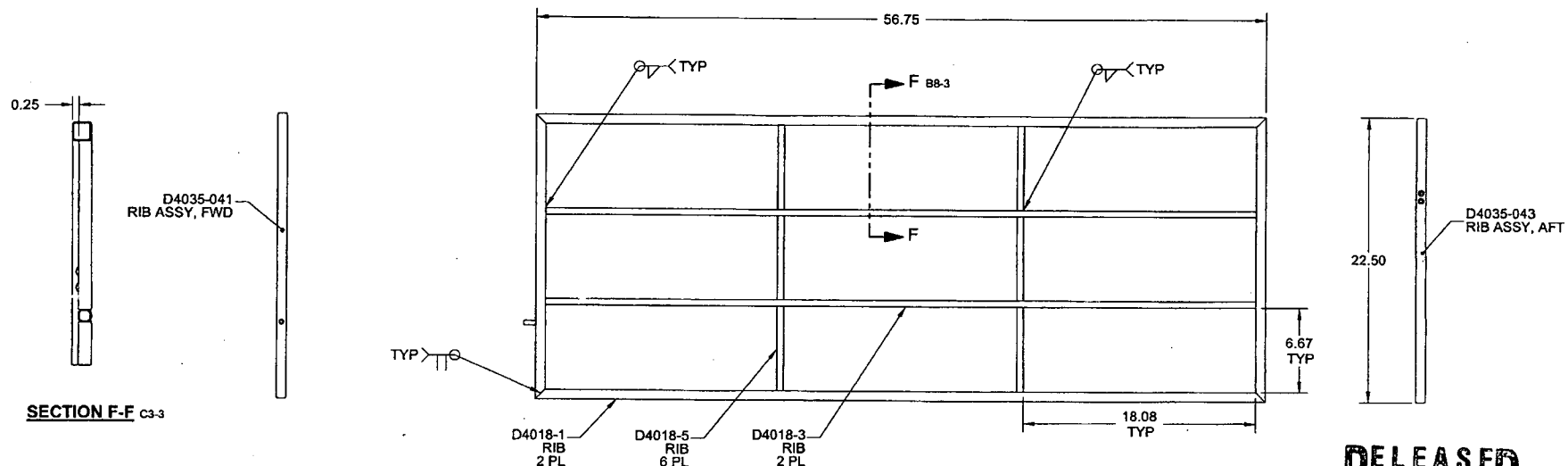
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| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|--------------------------------|
| | X | D4018-101 | TUBULAR ASSY, BASKET LID (350) |
| 1 | 2 | D4018-1 | RIB |
| 2 | 2 | D4018-3 | RIB |
| 3 | 6 | D4018-5 | RIB |
| 4 | 1 | D4035-041 | BASKET LID RIB ASSY, FWD |
| 5 | 1 | D4035-043 | BASKET LID RIB ASSY, AFT |







8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
2010-03-31

#59607

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

| | | | |
|--|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JRH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. |  | D4018 | SHEET 3 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | SHORT BASKET LID ASSY (350) | NTS |
| DATE | 10.03.25 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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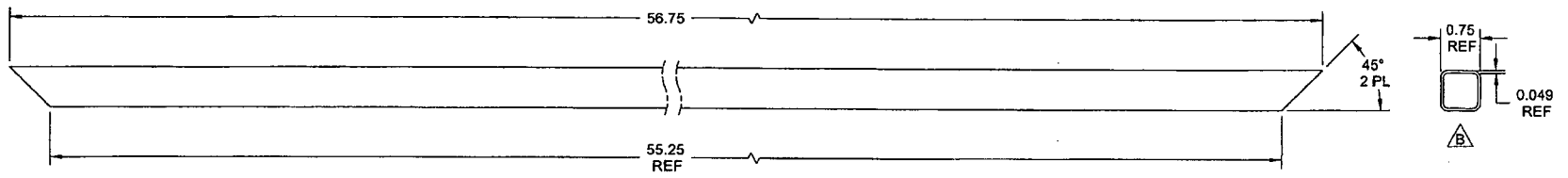
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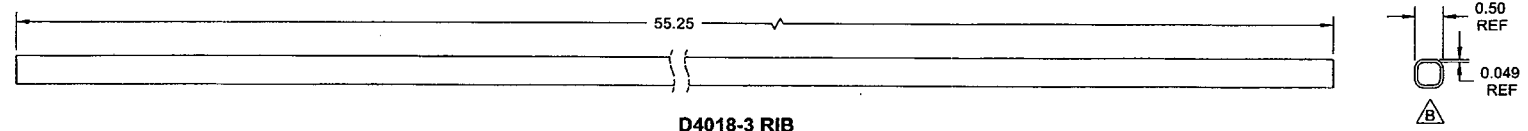
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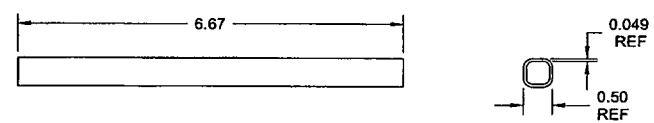
D4018-1 RIB

C



D4018-3 RIB

B



D4018-5 RIB

#59607

RELEASED
2010-03-31

NOTES:

- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 3 & -5: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

A

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JFH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4018 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SHORT BASKET LID ASSY (350) | NTS |
| DATE | 10.03.25 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries